

Work Order ID 92120 -1

Tuesday, October 23, 2012 4:11:59 PM

92120

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Item ID: PB67-43001-11

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012 Start Qty: 4.00 *4*

Required Date: 11/2/2012 Req'd Qty: 4.00 *4*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12-10-25 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001-11	Rev C								

100

100

Large Fab

0.00

Large Fab

Memo

0.00

Large Fab

1- make a 0.090" chamfer in the 1.00" hole before welding

2- assemble parts and weld as per dwg

3- grind weld flush in area of PB67-43001-249 only

4- install helicol insert as per dwg

(4x)

CC

12-17-4

110

110

QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

4

8

12-12-05

DAS
18

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Setup Start *NS1*

Revision ID:

Item Name: Fwf Adjustable Blade Support Assembly

Stop *NS2*

Start Date: 10/23/2012 Start Qty: 4.00 *4*

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			
Quality Control									
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				4		12-12-5	
Hand Finishing									
160 *160* Powdercoat	Green Sandtex(Ref:4.3.5.8) per QSI005 4.3 Memo	0.00 0.00				4X			
Powder Coating									

1- MASK TUBE FROM BASE TO GUSSET START TIME:
OVEN TEMPERATURE: 320°F FINISH

TIME:

ML6144

3-15

12/12/10

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N900040100

Setup Start *NS1*

NS?

Stop *NS2*

Start Date: 10/23/2012 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 11/2/2012 **Req'd Qty:** 4.00 *** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop. *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
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**Accept
Qty**

Reject
Qty

Reject Number

**Insp.
Stamp**

170 : QC3- Inspect Part Finish

0.00

170

QC

—Memo.

—0.00

Quality Control

180

0.00

1.80

Small Fab

Small Fab

Meme

0.00

Small Fab

~~1- match drill cover to existing holes in support 2- assemble as per dwg~~

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC-

Memo

0.00

Quality Control

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Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location: <i>WMA</i>	0.00							
200									
Packaging	Memo	0.00				1	<i>Ø</i>		<i>12-12-19</i>
Packaging									
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							<i>MC 12-12-19</i>
Quality Control									

W121219

Picklist Print

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Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec
dwg EC verified by:DD

IPP Rev B 10.09.27 per revC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
[REDACTED]		Manufactured	No		B93495 = 4		Each	1.0000		4		12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
					85187	1							
[REDACTED]		Manufactured	No		B90926 = 4	100	Each	0.0000	1	4		12-11-30	
[REDACTED]		Manufactured	No			100	Each	3.0000	1	4		12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438	B90927	3							
					52480	3							
[REDACTED]		Manufactured	No			100	Each	7.0000	1	4		12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7							
					85185	7							
[REDACTED]		Manufactured	No			100	Each	16.0000	1	4		12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST438		16							
					52481	16							
[REDACTED]		Purchased	No			180	Each	82.0000	1	4		12-11-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST333		82							
					111064	82							

Picklist Print

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Work Order ID: 92120

Parent Item: PB67-43001-11

Parent Item Name: Fwf Adjustable Blade Support Assembly

MS27039-1-10

Purchased No

180 Each

416.0000

8

32

Start Date: 10/23/2012

Required Date: 11/2/2012

Start Qty: 4.00

Required Qty: 4.00

Screw

Location

Loc Qty

Loc Code

308	123522	8
	122441	8
GA		100
	120449	100
ST291		5
	120120	5
ST305		300
	122815	300
ST308		3
	122027	3

168

12.12.19

NAS1149D0316J

Washer

Purchased No

180 Each

400.0000

8

32

Location

Loc Qty

Loc Code

ST298		400
	122151	400

168

12.12.19

NAS1149D0363J

Washer

Purchased No

180 Each

4,785.0000

8

32

Location

Loc Qty

Loc Code

ST294		1854
	123248	1254
	123355	600
ST297		2820
	122378	2820
ST298		111
	117601	61
	119537	33
	120308	17

168

12.12.19